

Date: Wednesday, 03/09/2008 8:52:16 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER  
 Job Number : 41708  
 Estimate Number : 10980  
 P.O. Number :  
 This Issue : 03/09/2008 S.O. No. :  
 Prsht Rev : NC Part Number : D2808  
 First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D2808 REV B  
 Previous Run : 37113 Project Number : N/A  
 Material : B  
 Due Date : 15/09/2008 Qty: 40 Um: Each  
 Written By :  
 Checked & Approved By : JUL 08 9.03  
 Comment : Est Rev:D 02.03.07 Now turned in house NG  
 Est Rev:E 07-12-18 RevB as per dwg ECN1048 DD verified  
 by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0625 6061-T6 Round Bar .625"



(112)

Comment: Qty.: 0.0557 f(s)/Unit Total : 2.2260 f(s)  
 6061-T6 Round Bar .625"  
 (M6061T6R0625)  
 Batch: M107513 x30

M108548 x12

mmw 08/09/04

2.0 HARDINGE HARDINGE CNC LATHE SMALL



M108548 x12

Comment: HARDINGE CNC LATHE SMALL

107513 x30

(42)

1-Turn as per Folio EA205 (Measure D3387 Bracket .507" Dia for Proper press-fit)

FA356

2-Deburr

mmw 08/09/04

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



M108548 x12

107513 x30

mmw 08/09/04

(42)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

mmw 08/09/04

(42)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

mmw

08-09-08

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 8:52:16 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 41708

Part Number: D2808

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-h 08/09/08* (42K)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *6-A*

*08/09/12* (42)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/09/12* *H*

Job Completion



*u 08.09.12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

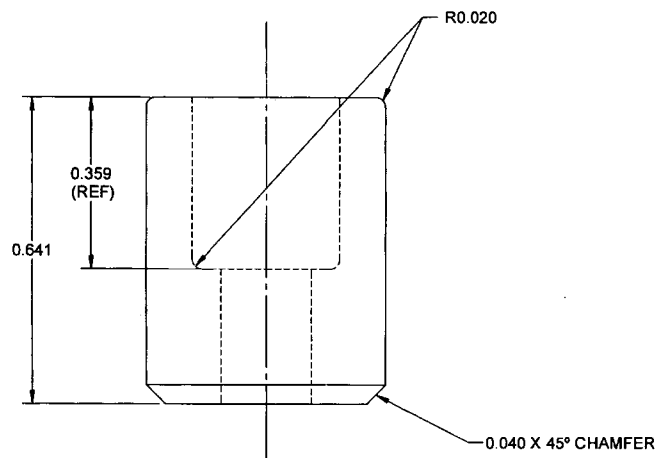
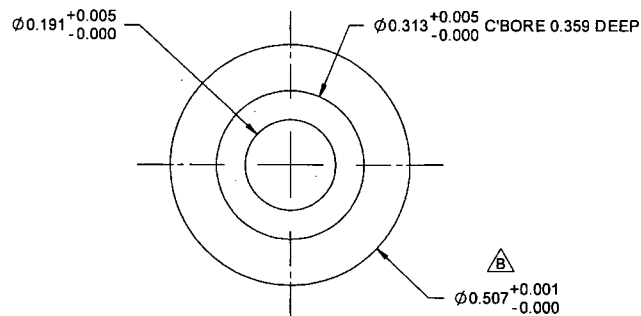
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





RELEASED  
07.12.12

NO. 4708  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
RETURN TO  
ENGINEERING  
SHOP COPY

**D2808 SPACER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

B	REMOVE POWDER COAT; Ø0.507 WAS Ø0.500	DC	07.10.12
A	NEW ISSUE	DS	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.12		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2808** REV. B  
SHEET 1 OF 1  
TITLE **SPACER** SCALE 4:1

COPYRIGHT © 2000 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.